

Date: Friday, 9/21/2007 1:19:15 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG BRACKET
Job Number : 34830	
Estimate Number : 10009	
P.O. Number : N/A	Part Number : D27351
This Issue : 9/21/2007 S.O. No. : N/A	Drawing Number : D2735 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 9/21/2007 Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 33488	Material : N/A
Written By : <u> </u>	Due Date : 10/5/2007 Qty: 40 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev C Removed from 9 Digit 05-10-25 JLM	
est rev D waterjet 06.09.19 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S125	1010-1025 sheet .125
-----	-----------	----------------------



7.7985



Comment: Qty.: 0.1733 sf(s)/Unit Total : 6.9300 sf(s)

1010-1025 sheet .125

batch:

106140 07-11-7

IB

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2735 (D2735-1)

Dwg Rev: Prog Rev:

07-11-7

IB

2-Deburr if necessary

07-11-7

IB

(45)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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07-11-7
IB 

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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SECOND CHECK

07-11-7

(45)



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204

2-Deburr if required.

SB 08/01/02

(45)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	2	Make						

Part No: D2735-1 PAR #: N/A Fault Category: Prod / FAR ASS ^{med & small} NCR: Yes ~~No~~ DQA: 1D Date: 08.01.09
 QA: N/C Closed: 1D Date: 08.01.10

NCR: <u>34830</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.31	2	made with 4130-107495 instead of 1010 Qty 41 scrap	<u>[Signature]</u> 05/10/12	<u>scrp & replace</u>	<u>IB</u> 07-11-8	<u>[Signature]</u> 07/11/09	<u>[Signature]</u> 05/10/12	<u>[Signature]</u> 07.10.31

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:19:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 34830

Part Number: D27351

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counts

Comment: INSPECT WORK TO CURRENT STEP

5 ~~08~~

08/01/03

(45)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

FC

08 01 09

(45)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(45)
12/08/01/09

Job Completion



08/01/09

U

08-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

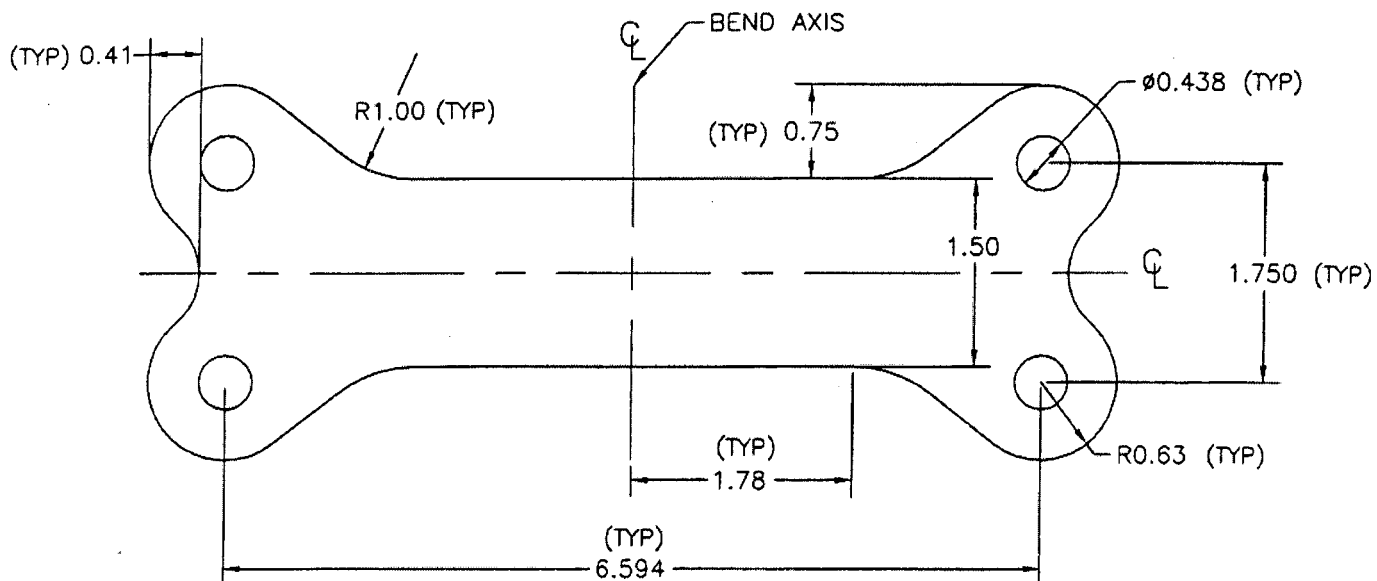
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

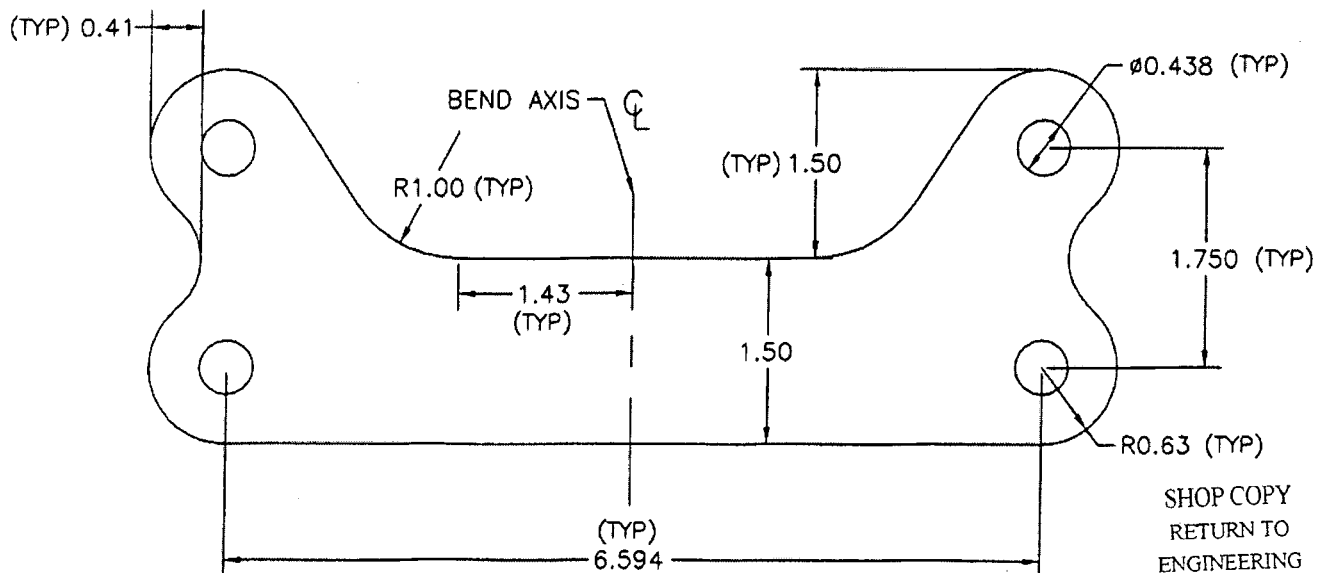


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED
98.12.14 DS



D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (CL)



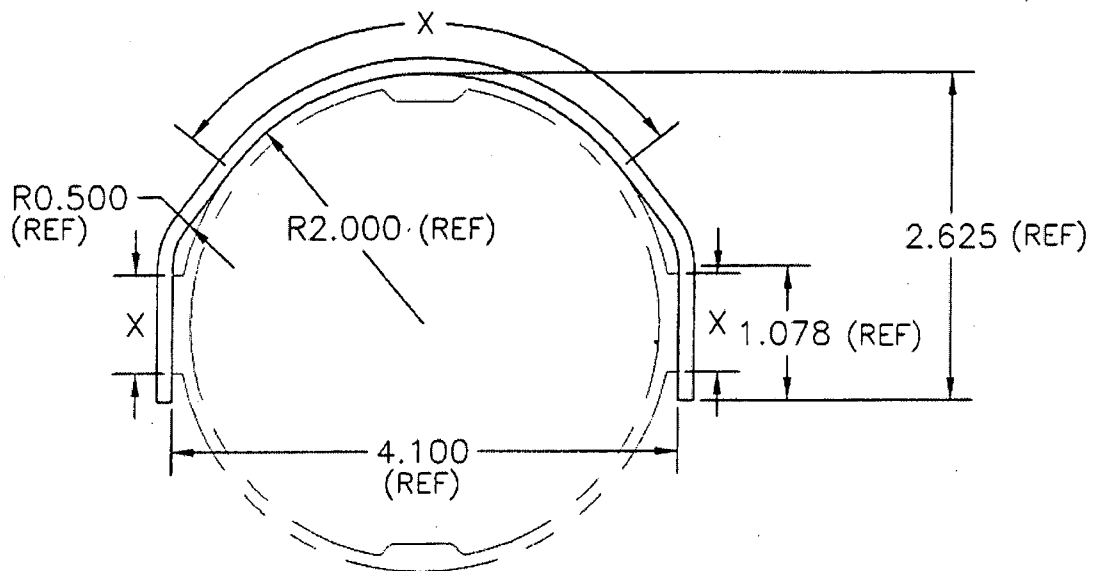
D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (CL)

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34830



DESIGN <i>AT</i>	DRAWN BY <i>AT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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NO. 34830